

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022340**Date Inspected:** 19-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zheng Zhi Wei, CWI Ji Cai Fang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BW

PCMK: SA3231A

Weld No: 009

Welder: 066179

Weld Repair No. B-WR20439

WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 13CW

PCMK: SEG3015G

Weld No: 009

Welder: 067993

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WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zheng Zhi Wei, CWI Ji Cai Fang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: SEG3020AQ

Weld No: 002,006,010,014

Welder: 045175, 201215

WPS-B-T-2232-ESAB

Components; OBG 14 W

PCMK: SEG3020AQ

Weld No: 004,008,011,016

Welder: 045175, 201215

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhong Yong Gang, CWI Tiang Zhi Wen.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W

PCMK: DP3089-001

Weld No: 019,020,022,023

Welder: 050969

WPS-B-P-2213-TC-U4b-FCM-1

Components; OBG 13CE

PCMK: VP3007-001

Weld No: 078,079,080

Welder: 051359

WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E

PCMK: DP3165-001

Weld No: 017,018,033,034

Welder: 050232

WPS-B-P-2113-TC-U4b-FCM-1

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Components; OBG 14 E
PCMK: SEG3019X
Weld No: 100
Welder: 043661, 044779
Weld Repair No, B-CWR2615
WPS-345-SMAW-2G(2F)-FMC-Repair-1

Components; OBG 14 E
PCMK: SEG3019BB
Weld No: 108,132,223
Welder: 215553
WPS-B-P-2113-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SP3121-001
Weld No: 003,004,005,006,083,084
Welder: 054013
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SA3358-001
Weld No: 006,007,004,005
Welder: 044790
WPS-B-P-2113-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhong Yong Gang, CWI Tiang Zhi Wen.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 E
PCMK: DP3165-001
Weld No: 112,113
Welder: 051356
WPS-B-T-2233-ESAB

Components; OBG 14 E
PCMK: SEG3015J
Weld No: 010
Welder: 066421, 067870
WPS-B-T-2232-ESAB

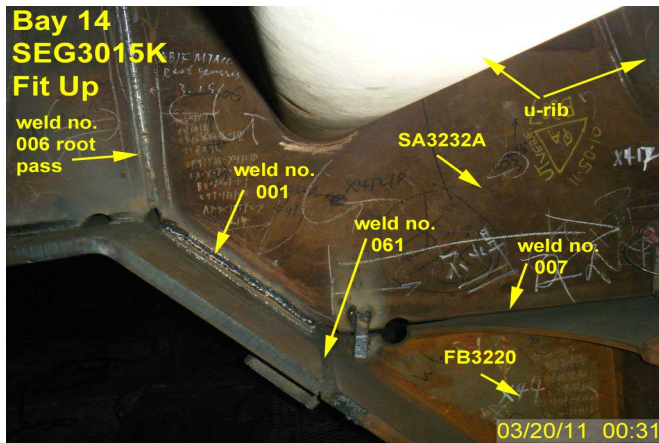
This QA Inspector observed the following work in progress for Bay 14. Fit up of weld joint 001, 006, 007, 061

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located on PCMK SEG3015K. Tack welder was not identified. ZPMC QC was identified as Zhong Yong Gang, CWI Tiang Zhi Wen. The Fit Up of this weld joint appeared to comply with contract documents. (see photo below)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt,Kelly

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer